

Date: Tuesday, 22/07/2008 11:27:12 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: TUBE		
Job Number	: 40713			Part Number	: D37701		
Estimate Number	: 13490			Drawing Number	: D3770 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/08/2008		
Previous Run	:			Qty:	12	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08.7.22</u>						
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w	
		Comment: Qty.: 1.1926 f(s)/Unit Total : 14.3111 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M100019</u>	FF 08-08-06 (12)
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	FF 08-08-06 (12)
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3770 2-drill holes thru to finish size as per dwg D3770 3- deburr	FF 08-08-06 (13)
3.0	QC5	INSPECT WORK TO CURRENT STEP	FF 08-08-11 (13)
		Comment: INSPECT WORK TO CURRENT STEP	08/08/11 (X12)
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	FF 08-08-11 (13)
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	08/08/11 (X12)
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	08/08/11 (X12)
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	08/08/11 (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3770-1 PAR #: N/A Fault Category: Prod/Fab. Ass' ^{med & small} NCR: Yes No DQA: Date: 08/08/06
 QA: N/C Closed: Date: 08/08/06

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/06	2	D3770-1 Hole was driven off center Part moved in vise on Drill Press R.C. vise was not tight enough. Human error	RJ	Hole off center error Scrap and replaced Qty 10 B&M 108B19	08/08/06 FF	C 08/08/06	RJ 08/08/06	C 08/08/06

NOTE: Date & initial all entries

Date: Tuesday, 22/07/2008 11:27:13 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 40713

Part Number: D37701

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



SO

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 135

8/8/11 (12)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-08-11

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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D

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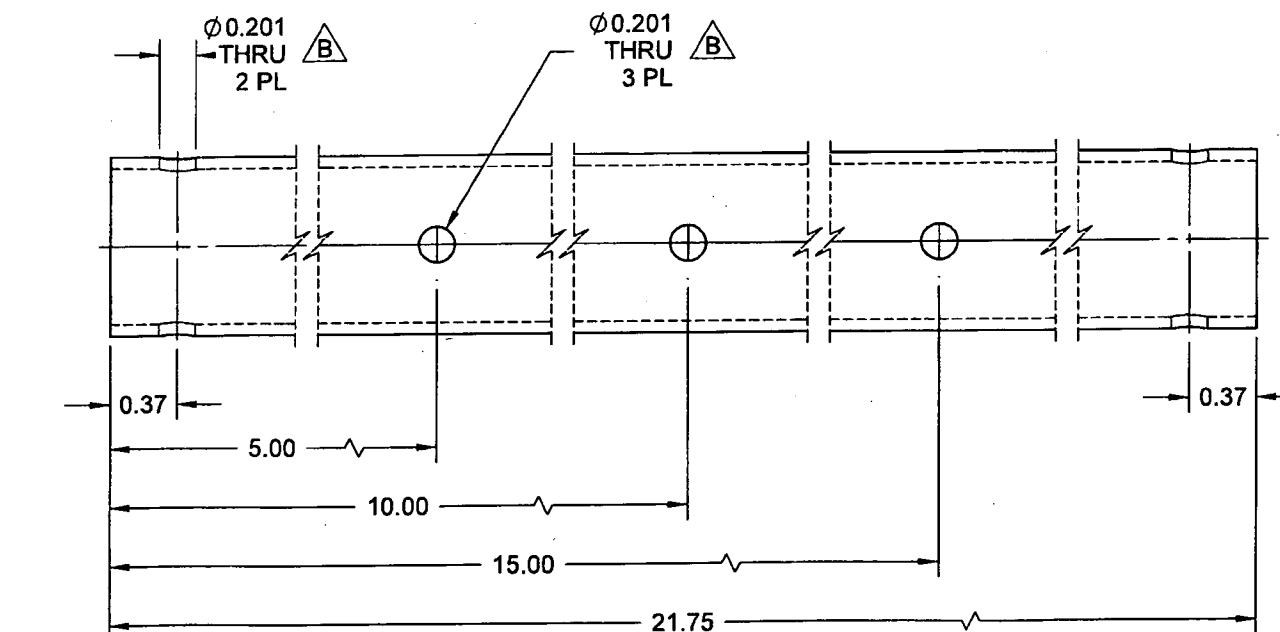
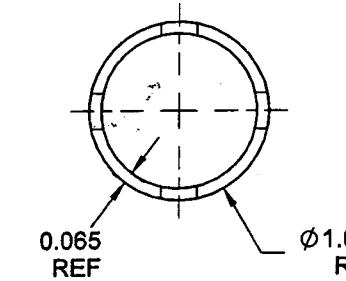
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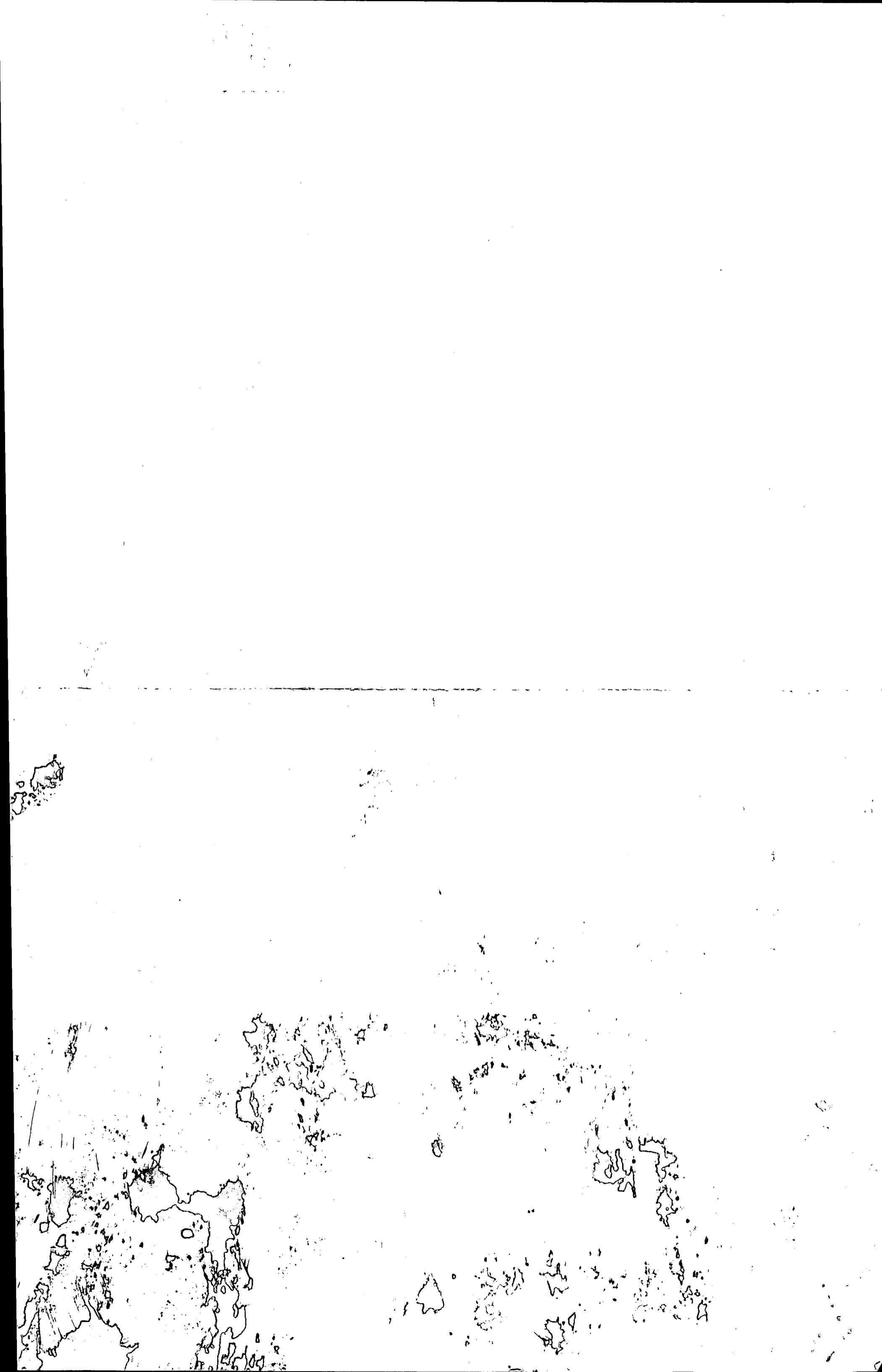


D3770-3 TUBE

RELEASED
08-07-10 7140

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WITHOUT NOTICE
WORK ORDER
NO. 7073

DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PF	DRAWING NO.			
MFG. APPR.	MM	REV. B			
APPROVED	MM	D3770 SHEET 3 OF 3			
DE APPR.	MM	TITLE			
DATE	08.06.23	SCALE			
		NTS			
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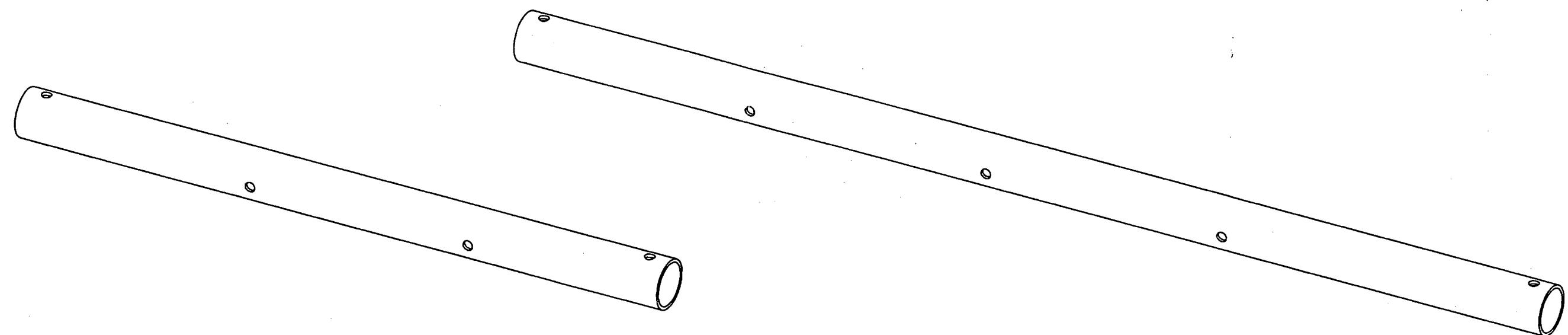
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D3770-1 TUBE

D3770-3 TUBE

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WITHOUT NOTICE

WORK ORDER

NO. 260713

Preliminary
08.07.10 /A

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>pet</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MM</i>	D3770	SHEET 1 OF 3
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	TUBE	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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- NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3770-1, 0.25 lbs
D3770-3, 0.40 lbs

8 7 6 5 4 3 2 1

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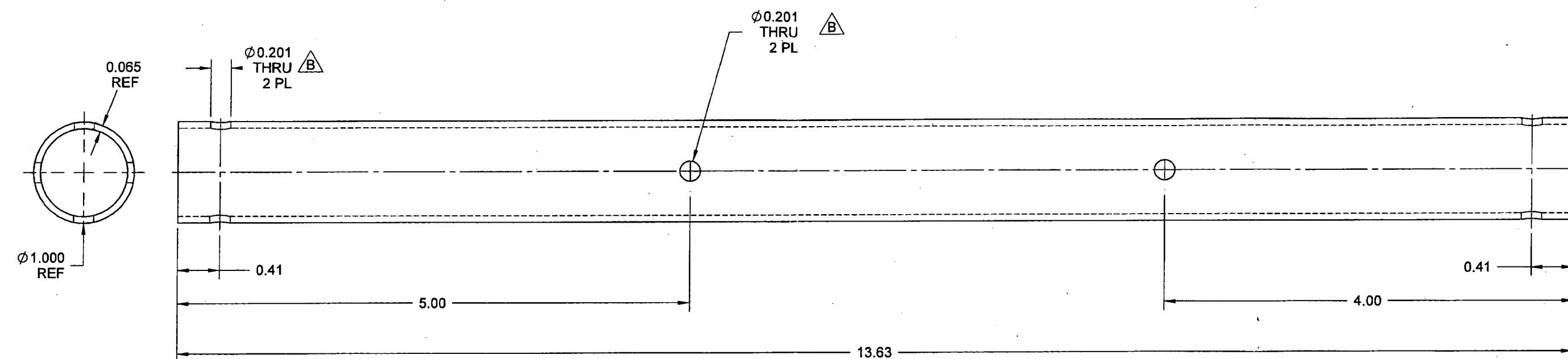
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D3770-1 TUBE

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WORK ORDER
NO. 40713

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08.07.10 11:14

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3770	
APPROVED		REV. B	
DE APPR.		SHEET 2 OF 3	
DATE	08.06.23	TITLE	SCALE
		TUBE	NTS

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